

# Work Order ID 58368

Tuesday, May 04, 2010 1:57:11 PM



SHIP MONDAY May 10th Page 1

Item ID: D3861-041

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 5/4/2010 Start Qty: 8.00 5



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3861 ☒ Dwg Rev: A ☐ Prog Rev: A ☐ 2-  
Deburr if necessary

B10-5-5

7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-5-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/05/05

66

Pro ->

Dart Aerospace Ltd

W/O: 58368		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/5/05	# 120	Took QTY +1 For QC inspection template	S	10/5/05	1		<i>[Signature]</i> 10/5/05

Part No: D3861-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3861 ☐ A/R 316L stainless steel rod  
Batch: M102421 ☐ 2-Weld hard facing as per Dwg D3861 ☐ A/R  
2059B Hard Coat rod Batch: M114460 ☐ \*\*\*\*\*use  
DT9463 for welding\*\*\*\*\*

EL 10-5-6 (46)

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(B) PD 10.05.07

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.05.07

(46)

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Revision ID:

Stop



Item Name: Wearplate

Start Date: 5/4/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M1125B8

Memo

0.00

START TIME:

9:15AM

OVEN TEMPERATURE:

9:45AM FINISH TIME:

320°F

del 10/05/07

X6 Ø

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

⑥ BR 10-5-7.

180



Packaging

Packaging

Identify as per dwg & Stock Location:

508

0.00

Memo

0.00

10-5-7 SF ⑥

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 5/10/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

60605107 *[Signature]*  
MF  
10-5-7

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# Picklist Print

Tuesday, May 04, 2010 1:57:11 PM

Page 1

Work Order ID: 58368

Parent Item: D3861-041

Parent Item Name: Wearplate



Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Start Date: 5/4/2010

Required Date: 5/10/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	110.5848	1.09	7.63		
 18 10-5-5												

Location

Loc Qty

Loc Code

MAT

110.5848

111323

0

114467

110.5848

D3009-3

Manufactured

No

130

Each

365.0000

6



Cup

Location

Loc Qty

Loc Code

WA

365

42377

365

14:167

EL 10-5-5

36

W/O:		WORK ORDER CHANGES					
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3861-041	WEARPLATE
2	1	D3861-1	WEARPLATE
3	6	D3009-3	CUP

2059B HARDCOAT  
10 PL

0.06  
TO  
0.13  
HIGH

1.00  
TYP

3.63  
TYP

1.50  
REF

C  
SYM

0.50

1.00

HARDCOAT WELD  
SURFACING  
REF

6 PL

1/32

6

D3861-1 WEARPLATE (1)

INSTALL D3009-3 FLUSH  
WITH THIS SURFACE  
TYP

D3009-3 CUP (6)

**D3861-041 WEARPLATE**

**RELEASED**  
# 09.01.26

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3861-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.69 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE	REV.	DESCRIPTION	BY	DATE
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	09.01.26				

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3861** REV. A  
SHEET 1 OF 2  
TITLE **WEARPLATE** SCALE NTS

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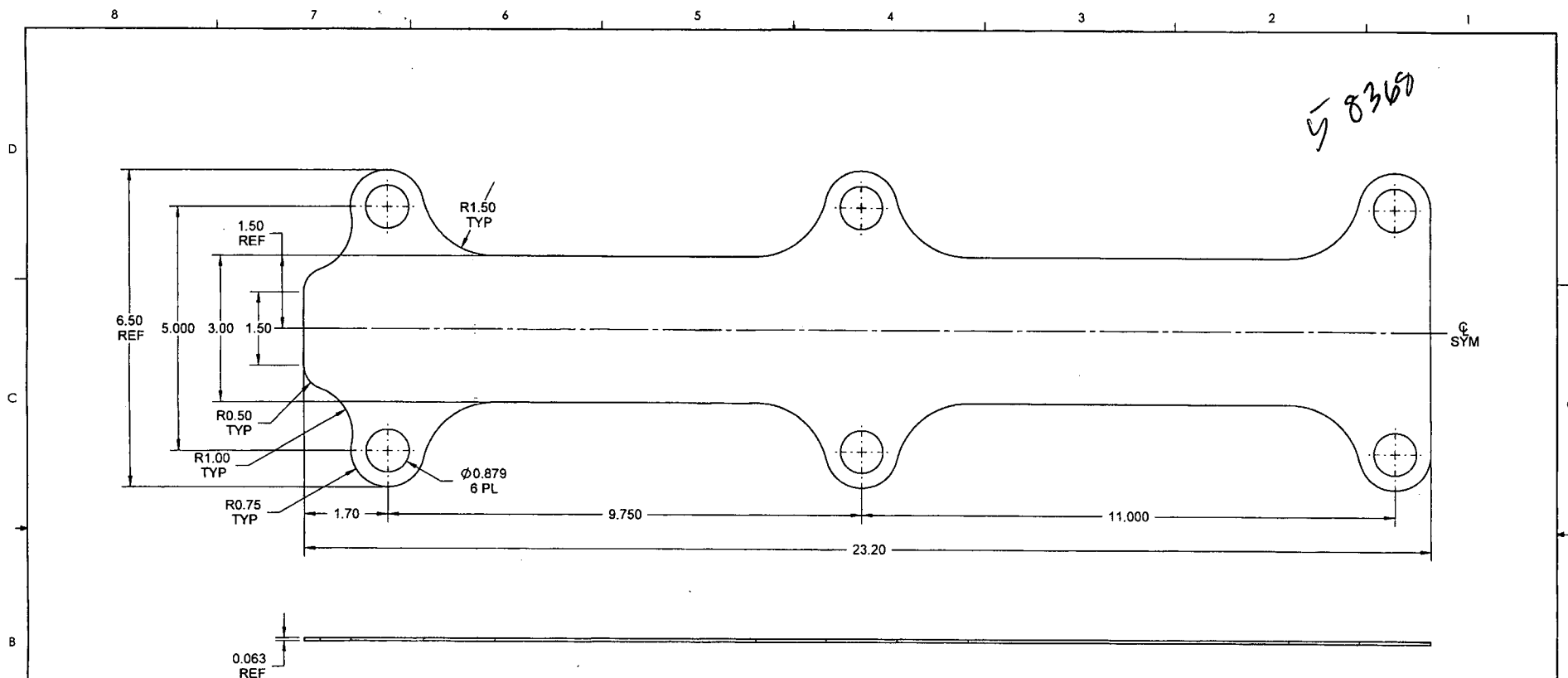
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**NOTE:** Date & initial all entries



**D3861-1 WEARPLATE**

**RELEASED**  
# 09.01.26

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.52 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3861	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	09.01.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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